



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D205-541-048
Job Sheet 177755



Part No: D205-541-048

Job Qty: 1 ea

Part Name: Heli-Access-Step™ - RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/17/18

Job Tracking No:

Due Date: 6/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV G SHEET 18 IPP Rev:A new issue 08-02-19 verified by: LL IPP Rev:B Ecn 1157 08-03-19 DD verified by: IPP Rev:C bolt was AN3 now AN4 DD 10.03.18 verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/12/18	6/12/18	0.00	0.00	Start Up Stores/Pkg-1		JUN 02 2018
100	Packaging	1 pcs	6/12/18	6/12/18	0.00	0.00	Packaging1-2		
110	QC	1 pcs	6/12/18	6/12/18	0.00	0.00	QC4		
115	DC	1 pcs	6/12/18	6/12/18	0.00	0.00	DC		
120	Packaging	1 pcs	6/12/18	6/12/18	0.00	0.00	Packaging3-1		
130	QC21-FG	1 Ea	6/12/18	6/12/18	0.00	0.00	QC21		

Part Op 115 - Photocopy blue file & type labels per PPPD205-541-048 CHG001

Descriptions: 120 - Identify and pack for shipping as per PPPD205-541-048 Location: _____ PPP Rev: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-13A	Bolt	6 Ea (6 ea)	90-Start up Operation	
AN4-14A	Bolt	6 Ea (6 ea)	90-Start up Operation	
AN960JD416	Washer	24 Ea (24 ea)	90-Start up Operation	
D3724-042	Step Assembly	1 Ea (1 ea)	90-Start up Operation	
D3731-1	Plate	2 Ea (1 ea)	90-Start up Operation	
D3751-1	Shim	2 Ea (2 ea)	90-Start up Operation	
MS21042L4	Nut	12 Ea (12 ea)	90-Start up Operation	
NAS1149D0463J	Washer	24 Ea (24 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-13A	6	1,581	0
	AN4-14A	6	503	0
	AN960JD416	24	0	0
	D3724-042	1	0	0
	D3731-1	1	12	0
	D3751-1	2	4	0
	MS21042L4	12	2,903	0
	NAS1149D0463J	24	6,295	0

Part Specifications

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition

Container No: S077306
Part: D205-541-048
Job No: 177755
Serial No/Batch: S077306
 Revision: _____
 Inspector: _____
 Exp Date: 06/02/2018
 Instructions: _____
 Date: 06/02/18

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 Haverhill, MA 01830
 CANADA
 TEL: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Root Cause			FAULT CATEGORY		
Environment	☐	No Re-verification	Pressure/Forced	☐	Temperature/Cure
Design	☐	Operator	Bending	☐	Set-up
Doc/Data	☐	Offset/Setup	Centre Not Concentric	☐	BOM/Route
Equip/Tooling	☐	Supplier	Cracks	☐	Broken/Damage/Defect
Handling/Pre	☐	Training	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified
Material	☐	Use for Testing	Cuffs	☐	Contamination
Internal Transport	☐	Poor Information	Crushing	☐	Countersink
Tribal Knowledge	☐	Rushing	Heat Treat	☐	Cut Too Short
LOA	☐	Product Improvement	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear
Substation	☐	Process Improvement	Marks/Chatter	☐	Drill Holes
Past Expiry Date	☐	Manufacturing Process			
Misidentified	☐	Past Due			
OTHER :					

☐	Part Moved
☐	Drawing
☐	Finish
☐	Misread
☐	Turning Sequence

Specifications could not be found.

Plex 5/17/18 12:55 PM Dart.lajeunesse.marie



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
003613	S077305	AN4-13A	Bolt	S062374	ST344	6
003613	S077304	AN4-14A	Bolt	S062375	ST344	6
003613	S010311	D3731-1	Plate	S010310	ST050	1
003613	S077303	D3751-1	Shim	S058997	ST050	2
003613	S077302	MS21042L4	Nut	S056039	ST303	12
003613	S077301	NAS1149D0463J	Washer	S055952	ST263	24

f38-134x1

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 6/2/18 8:03 AM dart.quirion.sonia

Qty -043	Qty -044	Qty -045	Qty -046	Qty -141	Qty -142	Part Number	Description
1*	1*	1*	1*			AN4-22A	BOLT
1*	1*	1*	1*			AN4-24A	BOLT
1	1	1	1			AN5-7A	BOLT
1	1	1	1			AN5-13A	BOLT
4*	4*	4*	4*			AN5-17A	BOLT
				5	5	AN960-10	WASHER (OR NAS1149F0363P) (OPTIONAL)
				20	20	AN960JD10L	WASHER (OR NAS1149D0332J)
2*	2*	6*	6*			AN960JD416	WASHER (OR NAS1149D0463J)
				2	2	AN960-416	WASHER (OR NAS1149F0463P) (OPTIONAL)
27	27	27	27	36	36	AN960JD416	WASHER (OR NAS1149D0463J)
2*	2*	2*	2*	4	4	AN960JD416L	WASHER (OR NAS1149D0416J)
4*	4*	4*	4*			AN960JD516	WASHER (OR NAS1149D0563J)
3	3	3	3			AN960JD516	WASHER (OR NAS1149D0563J)
2	2					AN960JD8	WASHER (OR NAS1149DN832J)
4*	4*	4*	4*			AN970-4	WASHER
2*	2*					MS20600AD4W3	RIVET
2*	2*	2*	2*	8	8	MS21042L3	NUT (OR MS21042-3)
				5	5	MS21042L3	NUT (OR MS21042-3) (OPTIONAL)
4*	4*	5*	5*			MS21042L4	NUT (OR MS21042-4)
16	16	16	16	20	20	MS21042L4	NUT (OR MS21042-4)
				2	2	MS21043L4	NUT (OR MS21043-4)
4*	4*	4*	4*			MS21042L5	NUT (OR MS21042-5)
2	2	2	2			MS21042L5	NUT (OR MS21042-5)

* = ASSEMBLED AT DART

6.0 PARTS LIST HELI-ACCESS-STEP™

Qty -047	Qty -048	Part Number	Description
X		D205-541-047	HELI-ACCESS-STEP, LH
	X	D205-541-048	HELI-ACCESS-STEP, RH
1		D3724-041	STEP ASSY, LH
	1	D3724-042	STEP ASSY, RH
2	2	D3731-1	PLATE
2	2	D3751-1	SHIM
6	6	AN4-13A	BOLT
6	6	AN4-14A	BOLT
24	24	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

Kim Johnston

From: Sonia Quirion
Sent: Monday, June 04, 2018 9:25 AM
To: Kim Johnston; Michelle GagnonDonovan
Subject: L/B

DSI 9585-013 S077256 X3 TODAY
DSI 9585-011 S07257 X3 TODAY
D412-698-042 S077316 X1 TODAY
D412-698-041 S077317 TODAY
D412-704-011 S077300 X1 RED AN WHITE
D205-541-048 S077306 X1
D205-541-055 S077325 X1
D350-567-031 S077341 X1
D206-642-257 S077277 X1
PLEASE THANK